<b>Work Order I</b> November-27-72 11			*938	18*						Page 1
Revision ID:	262-3		Accept	*N900	<b>040</b> °	100	)* s	etup Star Sto	1.73	S1*
Item Name: Cap Start Date: 11/2 Required Date: 12/0 Reference:	22/12 Start Qty: 6.0	· ·		Cust Item II Customer:	<b>D:</b>		•		, ZV	S2*
	ocess Plan: MLJ				te:	· ————	R	un Star Sto	17	R1*
QC	C:	Date:	SPC (Y/N):	Da	te:			. **	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr						-			
D3262	Rev E	1							<b>V</b> .	
100		<u> </u>	0.00					1		
*100* Bandsaw Jeaspa Bandsaw	Machi	anks: 6.000" x 0.500" x 5.40 ne as per Folio FA457 and E y for D3262-3		13/01	123		_6_	Ø	•	
110			•	• • •						
*110 *110* HAAS I	Memo	•	0.00 PD	13/01/	23		6	Ø		MARIN resolute sub-re-cor
HAAS CNC vertical macl	hine #1 Machi	ne as per dwg D3262	•						•	•
-120	QC2- Inspect parts	off machine FAI/FAIB	0.00		-					
*120*			fo	13/01/2	3		6	K		
QC	Memo		0.00	. •	•		T			
Quality Control								`\		

			DQA:	Date:
NCR:	Yes / I	NO WORK ORDER NON-CONFORMANCE / UPDATE		***************************************

									QA Closed:	Dat	te:			
Work Orde	er:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N NCR N	lo.				Rework Scrap Use-as-is Work Order Update	Machining Small Finish			1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
Root				Descri	ption of work order update	Initial	Ad	ction	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	n QC Inspector			
Doc/Data								-						
Equip/Tooling														
Operator														
Material														
Setup														
Other														
Process														
Supplier														
Training														
Unapproved		<u> </u>					*							
					F	AULT CATE	GORY							
Landin	g Gear			_	General				_					
ļ	Bending				Bend	Grain			Ovalized		Pressure/Forced			
	Centre No	ot Concer	ntric to C	)/S	BOM/Route	Hardw	are	1	Over/Under	tolerance	Temperature/Cure			
	Cracks			<u> </u>	Broken/Damaged	$\vdash$	ion Incomplete		Part Incorre	ct	Weld			
	Crushed/0	Crimped.		<u> </u>	Burrs	Instruc	tions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled			
	Cuffs				Contamination	Maint	enance		Part Moved					
	Heat Trea				Countersink	Mislab	eled		Positioned V	Vrong				
	Inspection		Tube	<u> </u>	Cut Too Short	Misrea	d	<u>L</u>	Power Loss/	Surge	Other			
	Ripples in			<u> </u>	Drill Holes	Offset								
Ļ	Torque W		xtrusion		Drawing	Out of	Calibration							
	Turning Sequence Finish			Out of Sequence										
	Wave/Tw	ist in Tuh	10		Folio		o Dimoncions	<b>→</b>						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 93818 \*93818\* Page 2 November-27-12 11:41:56 AM Accept D3262-3 Item ID: \*N900040100\* Setup Start Revision ID: Stop Item Name: Cap Start Otv: 6.00 Start Date: 11/22/12 Cust Item ID: Required Date: 12/07/12 **Reg'd Otv:** 6.00 Customer: Reference: Run Start Process Plan: **Tooling:** Date: Approvals: Date: Stop Date: SPC (Y/N): Date: Operation Sequence ID/ Tool ID Tool # Plan Reject Reject Set Up/ Accept Insp. Work Center ID Qty Description Run Hours Code Oty Number Stamp SAO 130 OC8- Inspect parts - second check 0.00 13/01/28 08 \*130\* 0.00 Memo Quality Control Identify as per dwg & Stock Location: UVA 00 \$ 0.00 140 \*140\* Packaging 0.00 Memo Packaging 150 OC21- Final Inspection - Work Order Release 0.00 \*150\* QC 0.00 Memo Quality Control

pl13-01-28

•								DQA:	Date:	
NCR: Ye	es / No			WORK ORDER NON-	CONFOR	MANCE / UF	PDATE	QA Closed:	Date:	
Work Order	·:			DISPOSITION		•	AGAINST DE	PARTMENT	/PROCESS	
Part No.  NCR No.				Rework Scrap Use-as-is Work Order Update	I	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other
Root				Description of work order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling		1								
Operator										
Material										
Setup										
Other									. '	
Process										
Supplier										
Training										Óé
Jnapproved			<u> </u>							
					FAULT CATE	GORY				

Landing	Gear	General				 
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	•
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short	Г	Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset	•	
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish	Г	Out of Sequence		-
	Wave/Twist in Tube	Folio		Outside Dimensions		 

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## **Picklist Print**

November-27-12 11:41:55 AM

Work Order ID:

93818

Parent Item:

D3262-3

Parent Item Name:

Cap

Start Date: 11/22/12

Required Date: 12/07/12

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP C05.03.10Removed P/O for liquid penetrant

inspectionKJ/JLM

IPP Rev:D as per ECN10-

	571 DD 10.05.10	verified :EC											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X06.000 6061-T6 Bar .500 x 6.00		Purchased	No			100	f	37.7693	0.45	2.8421053	PD	13/	01/23
				<b>Location</b>		Loc Qty	Lo	c Code					
				MAT004		37.7692632				<u> </u>			
				11250	67	1.7692632							
				12024	43	12			2.	8			
				12252	21	24				-			

							•					DO	QA:	Date	:	
NCR:	Yes	/ No					WORK ORDER NON-O	COI	NFORM	MANCE / UP	PDATE	QA Clos	ed:	Date		
Manle Ond						٦	DISPOSITION				AGAINST (	+ ***			-	
Work Ord	er:	<del></del>					Davis at I	7	-					Water let	_	F
Part I	N۵						Rework Scrap	1		Skid-tube Machining	Crosstube Small Fab	_	Water Jet Prod. Eng. Coor.			Engineering Quality
raiti	١٥.					ı	Use-as-is	1	1	noforming	Finishing	_		re/Packaging	$\dashv$	Other
NCR	No.						Work Order Update	_		Large Fab	Composite		J.(J,	Supplier		
Root		<u> </u>			Des	crip	tion of work order update		Initial	Ac	ction	Sign 8	Š.	<del></del>	Т	
Cause		Date	Step	Qty		o	r Non-conformance	Cr	nief Eng	Desc	cription	Date		Verification		QC Inspector
oc/Data					·											
quip/Tooling		ļ.														
perator		ļ													ļ	
/laterial	_						•									
etup	L															
ther	_															
rocess	_															
upplier	-						•									
raining															ı	
Inapproved		<u> </u>	L	<u> </u>				<u> </u>	LT CATE	CORV		<u>, 1</u>		i	L_	
Landi	ng (	Gear					General	AUI	LICAIL	JONT						
Larra	٦	Bending			ſ		Bend	Г	Grain		Γ	Ovalized	ł	Γ	$\neg_{P}$	ressure/Forced
		Centre No	ot Concer	ntric to (	o/s	_	BOM/Route		Hardwa	re	ŀ	<b>→</b>		tolerance	_	emperature/Cure
	Г	Cracks					Broken/Damaged		4	on Incomplete	ţ	Part Inco			_	Veld
		Crushed/	Crimped.				Burrs	$\vdash$	-	ions Incomplete	/Unclear	Part Los	t/M	issing	_	Vrong Stock Pulled
		Cuffs	-		ļ	П	Contamination		Mainte		ľ	Part Mo				-
	Heat Treat Countersink			Г	Mislabe	led	Ī	Position	ed V	Vrong						
	Inspection Strip in Tube Cut Too Short			Misread	İ		Power Loss/Surge		Surge		Other					
		Ripples in	Bend	•			Drill Holes		Offset		•	<del></del>				
	Torque Waves in Extrusion Drawing				Out of Calibration											
	Turning Sequence Finish				Out of S	Seauence						•				

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

DART AEROSPACE LTD	Work Order:	93818
Description: Cap	Part Number:	D3262-3
Inspection Dwg: D3262 Rev: E		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070 x 45°	+/-0.010	.070			VGRN	RAD-01
0.13	+/-0.030	• 133	:		MIZ	P40-09
R0.063	+/-0.010	-063	~		R.G.	
0.080	+/-0.010	,076	1		VGRN	PUD-01
0.25	+/-0.030	.253	·/		**	<b>3</b> 1
Ø5.005	+0.010/-0.000	5,008	<b>/</b>		41	CNC-OZ
Ø0.875	+/-0.010	.873	<b>/</b>		ı(	P4D-01
3.25	+/-0.005	3,250	/		1.	PLID-01
Ø0.516	+0.005/-0.000	.517	/		84	1,
Ø5.165	+/-0.010	5, 165	/		, L	"
		•				
0.696	+0.007/-0.008	. 696	/		١.	4
0.588	+0.005/-0.000	. 588	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \		<b>b</b> t	*,
0.091	+0.007/-0.008	-091	W		4.	B g
0.45	+/-0.030	. 444	-		11	4
him the						

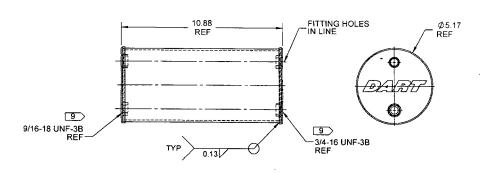
Measured by:	10	Audited by:	4.9	OAS	Preliminary Approval:	N/A
Date:	13/01/23	Date:	13/01/28	8-89	Date:	N/A

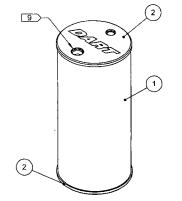
Rev	Date	Change	Revised by	Approved
Α	04.09.03	New Issue P/O D3262-041	KJ/JLM	
В	05.04.28	Dimensions and tolerances revised	KJ/JLM	
С	06.09.27	Dimensions revised per rev. C	KJ/JLM	
D	07.09.06	0.080 was 0.090	KJ/JLM .	1.4
E	10.08.03	Dimensions update per Dwg Rev E	KJ KL	M

QTY -041 ITEM P/N DESCRIPTION D3262-041 CANISTER ASSEMBLY SHOP TURE D3262-1 2 D3262-3 CAP RELEASE L ENGINE Trans-UNCONTROLL \*\* \*\* \*\* SUBJECT TO AVE DES WITHOUT NOT IN WORK OR: NO 93818 HLT 12-11-28 10.88 REF -FITTING HOLES Ø5.17 REF D3262-041 CANISTER ASSEMBLY 0.25 WAS 0.45 (ZNC7-4, C7-5); 0.13 WAS 0.33 (ZN B7-4, B7-5); AOD DIMENSION (ZN B1-4, D1-5, B1-5) 10.05.03 ADD D3262-043/-5 (ZN B5-2; B5-5); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN B2-4; C2-4) PER CAR D RF 09.12.30 Ø5.165 WAS Ø5.190 С RF 06.08.31 NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
8) INENTEGOATION. IDENTIFY WHITH COAD TON 173262 044" AND PAN LICING EN B ADD PRESSURE TESTING OPTION MB 05.02.14 A NEW ISSUE RF 04.05.06 REV. DESCRIPTION BY DATE DESIGN RF DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE POINT PERMANENT INK MARKER CHECKED DRAWING NO. REV. E D3262 MFG. APPR. SHEET 1 OF 5 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS APPROVED TITLE SCALE **FUEL PURGE CANISTER** DE APPR. NTS COPYRIGHT © 2004 BY DART AEROSPACE LTD IS FRANTE AND CONFIDENTIAL AND IS SUPPLED ON THE EURESS CONDIT DATE 10.05.03 7 6

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ITEM	QTY -043	P/N	DESCRIPTION
	X	D3262-043	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-5	CAP





D3262-043 CANISTER ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "03262-043" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 2.50 Ibs
8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<b>\$</b>	DRAWING NO.	REV. E
MFG. APPR.	9/	D3262	SHEET 2 OF 5
APPROVED	10	, TITLE	SCALE
DE APPR.	-4	FUEL PURGE CANISTER	NTS
DATE 10.05.03		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE CONFIDENCE ON COMMUNICATION TO ANY OTHER PERSON WITHOUT WHATTEN PERSONS WITHOUT AND MARY ARROSPACE TO	

4 Ø5.00 0.13 REF **D3262-1 TUBE** NOTES: 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T6T5.000W.125 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. E D3262 MFG. APPR. SHEET 3 OF 5 7) WEIGHT: 1.96 lbs
8) PART IS SYMMETRICAL ABOUT CENTERLINE APPROVED TITLE

FUEL PURGE CANISTER DE APPR. NTS DATE 10.05.03

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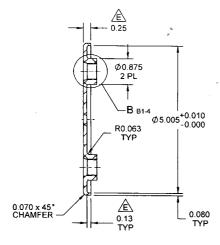
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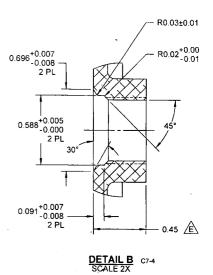
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DRILL THRU Ø0.516 (33/64 DRILL), TAP HOLE 9/16-18 UNF-3B B6-4 PER MIL-S-8879 Ø 5.165 2 PL REF 1.63 3.25 REF 6



SECTION A-A C5-4

D3262-3 CAP

NOTES:
1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARD EDGES: 0.005 TO 0.040 MAY

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN 7) WEIGHT: 0.28 lbs 8) PART IS SYMMETRICAL ABOUT CENTERLINE

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DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	45	DRAWING NO.	REV. E
MFG. APPR.	91	D3262 s	HEET 4 OF 5
APPROVED	149	TITLE	SCALE
DE APPR.	-111-	FUEL PURGE CANISTER	NTS
DATE 10.05.03		COPYRIGHT © 2004 BY DART A EROSPACE LTD THIS DOCUMENT OF PRIVATE NO COMPONENT, AND IS SERVICE OF THE EXPRESS CONTROL THAT IT IS HOT TO BE USED FOR ANY PURPOSE OR COMED OR QUANIFICATED TO ANY OTHER PERSON WITHOUT MINISTREPS PRIVATE PROMISSION FROM DARK ARGOPACE, TO	

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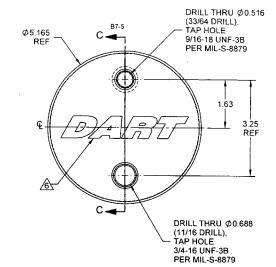
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93818

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Ø0.875 2 PL -D c2-5 05-0.010 -0.000 R0.063 TYP -E A2-5 0.070 x 45° CHAMFER 0.080 0.13 TYP

SECTION C-C D5-5



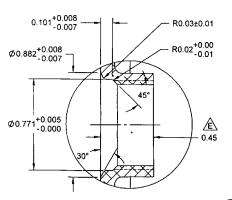
D3262-5 CAP

NOTES:
1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M0061T6B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
7) WEIGHT: 0.27 lbs

7) WEIGHT: 0.27 lbs 8) PART IS SYMMETRICAL ABOUT CENTERLINE

0.091+0.007 R0.03±0.01 -0.008 R0.02<sup>+0.00</sup><sub>-0.01</sub> Ø0.696<sup>+0.007</sup> Ø0.588<sup>+0.005</sup> £ 0.45

DETAIL D C7-5



DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	15.	DRAWING NO.	REV. E	
MFG. APPR.	91	D3262	SHEET 5 OF 5	
APPROVED	1.0	TITLE	SCALE	
DE APPR.	-##	FUEL PURGE CANISTER	NTS	
DATE 10.	05.03	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND OWNERSHIPMEN OF THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COMPANION TO TO ANY OTHER PURSON WITHOUT		

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